








Work Order ID 58214


Thursday, April 29, 2010 10:38:22 AM

Page 1

Item ID:	D3535-39	Accept		Setup	Start	
Revision ID:						
Item Name:	Wearshoe				Stop	
Start Date:	4/29/2010	Start Qty: 8.00		Cust Item ID:		
Required Date:	5/14/2010	Req'd Qty: 8.00		Customer:		
Reference:						


Approvals:	Process Plan:	<u>mf</u>	Date:	<u>04-29</u>	Tooling:		Date:		Run	Start	
	QC:		Date:		SPC (Y/N):		Date:			Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3535	Rev B								


100		0.00							
	FLOW WATER JET								
Waterjet									
FLOW CNC Waterjet	Memo	0.00							
304 .040	1-Cut as per Dwg D3535 <input type="checkbox"/> Dwg Rev: <u>B</u> <input type="checkbox"/> Prog Rev: <u>B</u> <input type="checkbox"/> 2- Debur if necessary								

B10-5-5

(13)

110		0.00							
	QC2- Inspect parts off machine FAI/FAIB								
QC									
Quality Control	Memo	0.00							

B10-5-5

120		0.00							
	QC8- Inspect parts - second check								
QC									
Quality Control	Memo	0.00							

Subs

(X12)

flb →

W/O: 58214		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
10/5/05	#120	Took Qty #1 For QC inspection template	S	10/5/05	1		S 10/5/05

Part No: D3535-39 PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

Work Order ID 58214

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Page 2

Item ID: D3535-39

Accept



Setup Start



Revision ID:

Item Name: Wearshoe

Stop



Start Date: 4/29/2010 Start Qty: 8.00



Cust Item ID:

Required Date: 5/14/2010 Req'd Qty: 8.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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130



Brake NC

NC BRAKE

0.00

Memo

0.00

Brake NC

Deburr if necessary ☐ Form on Brake as per Dwg D3535 using Jigs DT8261 and DT8326. ☐ Identify as D3535-41 ☐ Form Joggle on brake using Jig DT8158 as per Dwg D3535

Solo 5/10/10

(12)

0

140



QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

Memo

0.00

Solo 5/10/10

(12)

150



Powdercoat

Powder Coating

Grey Sandtex (Ref: 4.3.5.6) per QSI005 4.3

0.00

Memo

0.00

START TIME: *1:00pm* FINISH TIME: *3:20pm* OVEN TEMPERATURE: *320°C*

7/12 10/05/10

7/12

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Page 3

Item ID: D3535-39

Accept



Setup Start



Revision ID:

Item Name: Wearshoe

Stop



Start Date: 4/29/2010 Start Qty: 8.00



Cust Item ID:

Required Date: 5/14/2010 Req'd Qty: 8.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

160

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

(12)

BR 10-5-10.

170

Identify as per dwg & Stock Location: FP-18

0.00



Packaging

Memo

0.00

Packaging

JU 10/05/10

YR 2

180

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/05/12

MF

10-5-20

W/O:		WORK ORDER CHANGES					
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Picklist Print

Thursday, April 29, 2010 10:38:22 AM

Page 1

Work Order ID: 58214



Parent Item: D3535-39



Parent Item Name: Wearshoe

Start Date: 4/29/2010

Required Date: 5/14/2010

Comments: IPP Rev:A New Issue 07-02-15 JLM

Start Qty: 8.00

Required Qty: 8.00

IPP Rev:B As per Rev B 07-08-31 JLM Verified By:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Qty Issued	Date Issued	Status
M304S20GA		Purchased	No			100	sf	11.4800	0.951	12.363		



304/316 .040 Sheet



18 10-55

Location

Loc Qty

Loc Code

MAT20

11.48

112885

5

113062

6.48

114574

114574

13

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NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order: 58214
Description: Wearshoe		Part Number: D3535-39
Inspection Dwg: D3535	Rev: B	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
36.815	+/-0.010	36.815	*			
32.775	+/-0.010	32.775	*			
29.275	+/-0.010	29.275	*			
25.775	+/-0.010	25.775	*			
23.250	+/-0.010	23.250	*			
19.750	+/-0.010	19.750	*			
17.750	+/-0.010	17.750	*			
14.250	+/-0.010	14.250	*			
9.500	+/-0.010	9.500	*			
4.750	+/-0.010	4.750	*			
2.000	+/-0.010	2.000	*			
5.00	+/-0.030	5.00	*			
9.00	+/-0.030	9.00	*			
28.00	+/-0.030	28.00	*			
Ø0.188	+0.005/-0.001	.191	*			
1.885	+/-0.010	1.889	*			
0.300	+/-0.010	302	*			
0.300	+/-0.010	-304	*			
0.038	+/-0.010	.034	*			

Measured by: B
Date: 10-5-5

Audited by: S
Date: 10/05/05

Prototype Approval:	N/A
Date:	N/A

Rev	Date	Change	Revised by	Approved
A	07.07.18	New Issue	KJ/JLM	BE

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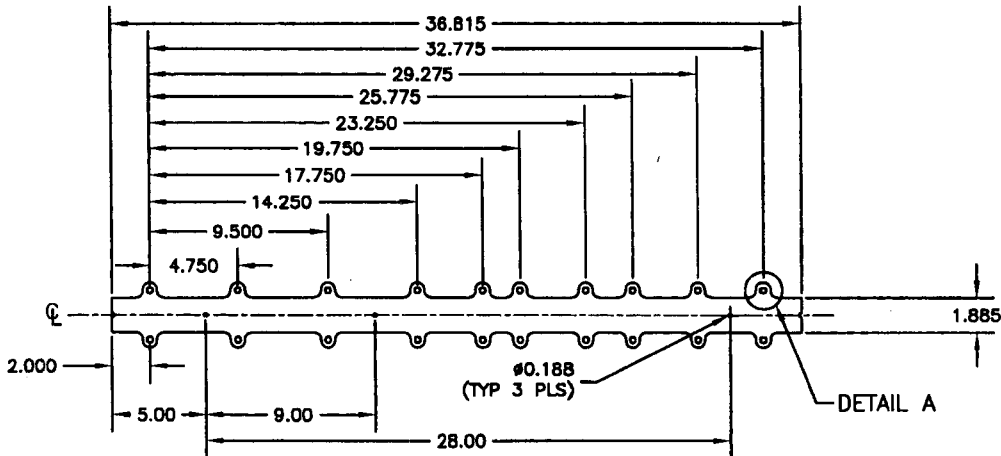
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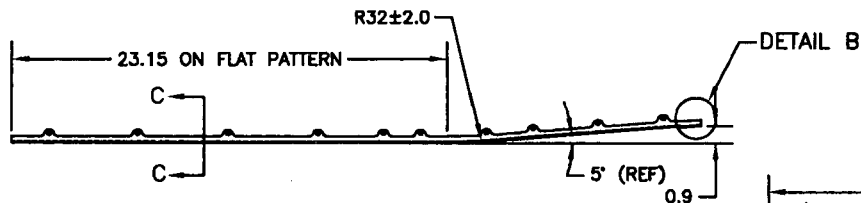
NOTE: Date & initial all entries

DART

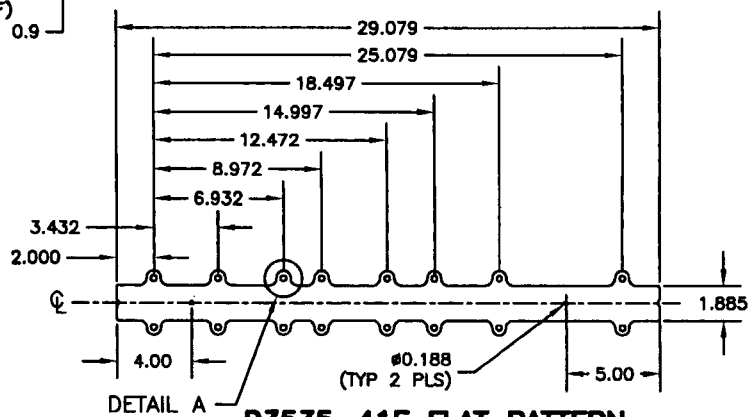
07.04.24



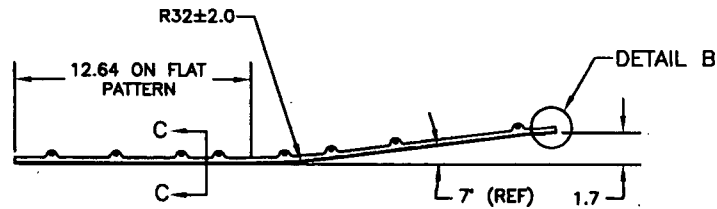
D3535-39F FLAT PATTERN



D3535-39 BEND DETAIL





D3535-41F FLAT PATTERN



D3535-41 BEND DETAIL

- 1) MATERIAL: AISI 304/316 SS SHEET PER AMS 5513 OR AMS 5524,
20 GAUGE (0.038 THICK)
(REF DART SPEC M304S20GA)
- 2) FINISH: POWDER COAT GREY SANDTEX (4.3.5.6) PER
QSI 005 4.3
- 3) PART IS SYMMETRICAL ABOUT ϕ
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS
OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP EDGES TO 0.010 MAX
- 7) IDENTIFY WITH DART P/N USING WHITE FINE POINT
PAINT MARKER
- 8) SEE PAGE 7 FOR DETAILS AND SECTION

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DESIGN	CB	DRAWN BY	PH	DART AEROSPACE USA, INC.	
				PORT HADLOCK, WA	
CHECKED		APPROVED		DRAWING NO.	REV. B
				D3535	SHEET 6 OF 7
DATE				TITLE	SCALE
07.04.17				WEARSHOE	1:10

W/O:		WORK ORDER CHANGES					
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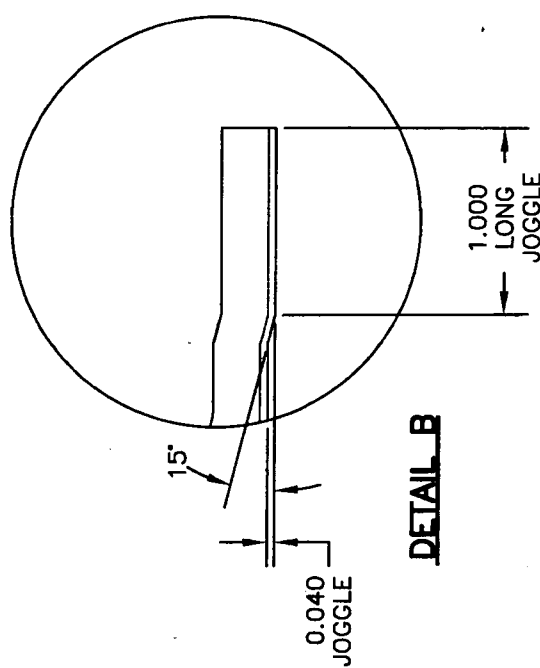
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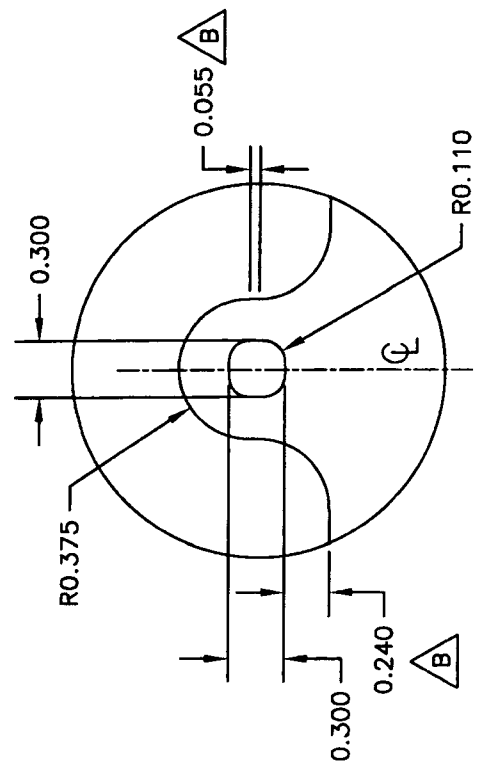


DESIGN CB	DRAWN BY PH	DART AEROSPACE USA, INC. PORT HADLOCK, WA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3535	REV..B SHEET 7 OF 7
DATE 07.04.17		TITLE WEARSHOE	SCALE 1:1

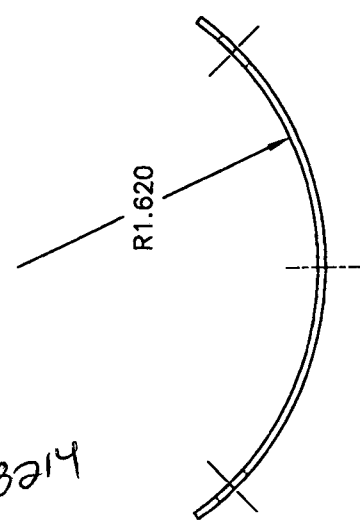
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07.04.24 *[Signature]*



DETAIL B



DETAIL A



SECTION C-C

#58214

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